

Section 1. Registration Information

Source Identification

Facility Name:	Taylor Farms Food Services
Parent Company #1 Name:	Taylor Farms of California
Parent Company #2 Name:	

Submission and Acceptance

Submission Type:	Re-submission
Subsequent RMP Submission Reason:	5-year update (40 CFR 68.190(b)(1))
Description:	
Receipt Date:	02-Aug-2010
Postmark Date:	02-Aug-2010
Next Due Date:	02-Aug-2015
Completeness Check Date:	02-Aug-2010
Complete RMP:	Yes
De-Registration / Closed Reason:	
De-Registration / Closed Reason Other Text:	
De-Registered / Closed Date:	
De-Registered / Closed Effective Date:	
Certification Received:	Yes

Facility Identification

EPA Facility Identifier:	1000 0020 1809
Other EPA Systems Facility ID:	

Dun and Bradstreet Numbers (DUNS)

Facility DUNS:	
Parent Company #1 DUNS:	22000509
Parent Company #2 DUNS:	

Facility Location Address

Street 1:	10241 South Avenue 4E
Street 2:	
City:	Yuma
State:	ARIZONA
ZIP:	85365
ZIP4:	
County:	YUMA

Facility Latitude and Longitude

Latitude (decimal):	32.673333
Longitude (decimal):	-114.563611
Lat/Long Method:	Interpolation - Digital map source (TIGER)
Lat/Long Description:	Center of Facility
Horizontal Accuracy Measure:	20
Horizontal Reference Datum Name:	World Geodetic System of 1984
Source Map Scale Number:	

Owner or Operator

Operator Name:	Taylor Farms of California
Operator Phone:	(831) 754-0471

Mailing Address

Operator Street 1:	PO BOX 1649
Operator Street 2:	
Operator City:	Salinas
Operator State:	CALIFORNIA
Operator ZIP:	93901
Operator ZIP4:	
Operator Foreign State or Province:	
Operator Foreign ZIP:	
Operator Foreign Country:	

Name and title of person or position responsible for Part 68 (RMP) Implementation

RMP Name of Person:	Jack Arthur
RMP Title of Person or Position:	RMP Administrator
RMP E-mail Address:	jarthur@taylorfarms.com

Emergency Contact

Emergency Contact Name:	Jack Arthur
Emergency Contact Title:	RMP Administrator
Emergency Contact Phone:	(928) 751-3081
Emergency Contact 24-Hour Phone:	(831) 970-2830
Emergency Contact Ext. or PIN:	
Emergency Contact E-mail Address:	jarthur@taylorfarms.com

Other Points of Contact

Facility or Parent Company E-mail Address:	
Facility Public Contact Phone:	(831) 754-0471
Facility or Parent Company WWW Homepage Address:	http://www.taylorfarms.com/default.asp

Local Emergency Planning Committee

LEPC:	Yuma County LEPC
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Full Time Equivalent Employees

Number of Full Time Employees (FTE) on Site:	950
FTE Claimed as CBI:	

Covered By

OSHA PSM :	Yes
EPCRA 302 :	Yes
CAA Title V:	
Air Operating Permit ID:	

OSHA Ranking

OSHA Star or Merit Ranking:

Last Safety Inspection

Last Safety Inspection (By an External Agency) 20-Feb-2009
Date:
Last Safety Inspection Performed By an External Agency: EPA

Predictive Filing

Did this RMP involve predictive filing?:

Preparer Information

Preparer Name: KIE Consultants, LLC
Preparer Phone: (928) 782-8095
Preparer Street 1: 250 W. 24th Street
Preparer Street 2: Suite O
Preparer City: Yuma
Preparer State: ARIZONA
Preparer ZIP: 85364
Preparer ZIP4:
Preparer Foreign State:
Preparer Foreign Country:
Preparer Foreign ZIP:

Confidential Business Information (CBI)

CBI Claimed:
Substantiation Provided:
Unsanitized RMP Provided:

Reportable Accidents

Reportable Accidents: See Section 6. Accident History below to determine if there were any accidents reported for this RMP.

Process Chemicals

Process ID: 1000018944
Description: Basic Inorganic Chemicals
Process Chemical ID: 1000022528
Program Level: Program Level 3 process
Chemical Name: Ammonia (anhydrous)
CAS Number: 7664-41-7
Quantity (lbs): 25000
CBI Claimed:
Flammable/Toxic: Toxic

Process NAICS

Process ID:	1000018944
Process NAICS ID:	1000019286
Program Level:	Program Level 3 process
NAICS Code:	115114
NAICS Description:	Postharvest Crop Activities (except Cotton Ginning)

Section 2. Toxics: Worst Case

Toxic Worst ID: 1000015035

Percent Weight:	100.0
Physical State:	Gas liquified by refrigeration
Model Used:	Areal Locations of Hazardous Atmospheres [ALOHA(R)]
Release Duration (mins):	10
Wind Speed (m/sec):	1.5
Atmospheric Stability Class:	F
Topography:	Rural

Passive Mitigation Considered

- Dikes:
- Enclosures:
- Berms:
- Drains:
- Sumps:
- Other Type:

Section 3. Toxics: Alternative Release

Toxic Alter ID: 1000016544

Percent Weight:	100.0
Physical State:	Gas liquified by refrigeration
Model Used:	Areal Locations of Hazardous Atmospheres [ALOHA(R)]
Wind Speed (m/sec):	1.8
Atmospheric Stability Class:	D
Topography:	Rural

Passive Mitigation Considered

Dikes:
Enclosures:
Berms:
Drains:
Sumps:
Other Type:

Active Mitigation Considered

Sprinkler System:	
Deluge System:	
Water Curtain:	
Neutralization:	
Excess Flow Valve:	
Flares:	
Scrubbers:	
Emergency Shutdown:	
Other Type:	Emergency Response and Diffusion Tank

Section 4. Flammables: Worst Case

No records found.

Section 5. Flammables: Alternative Release

No records found.

Section 6. Accident History

No records found.

Section 7. Program Level 3

Description

Taylor Farms maintains an accidental release prevention program to eliminate or minimize releases. The program includes equipment monitoring, regular inspections and maintenance, and log keeping of (1) operating conditions, (2) scheduled maintenance, (3) emergency response, and (4) operator training.

The ammonia refrigeration-operation system has specific safety measures in place to prevent accidental release. All pressure relief valves for the fixed system are tied in with diffusion tanks to mitigate a high pressure release incident. Operators and mechanics are trained for safe operation and maintenance of the refrigeration system. They are also trained in emergency response procedures in the event of an ammonia release.

A thorough examination of the system that included a "What If" hazard analysis, was performed in accordance with update requirements.

Safety and equipment operational training will be conducted at a minimum at least once a year. Training topics will include (1) equipment operational procedures, (2) emergency response procedures, (3) a review of the Risk Management Plan, (4) a review of the Business Response Plan, and (5) evacuation procedures.

Refrigeration equipment will be inspected and reviewed regularly and as new equipment becomes operational onsite. This RMP, which includes accident prevention procedures for the ammonia refrigeration system, is maintained onsite.

Program Level 3 Prevention Program Chemicals

Prevention Program Chemical ID:	1000018700
Chemical Name:	Ammonia (anhydrous)
Flammable/Toxic:	Toxic
CAS Number:	7664-41-7

Prevention Program Level 3 ID:	1000015636
NAICS Code:	115114

Safety Information

Safety Review Date (The date on which the safety information was last reviewed or revised):	15-Jan-2009
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Process Hazard Analysis (PHA)

PHA Completion Date (Date of last PHA or PHA update):	18-Feb-2009
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The Technique Used

What If:	Yes
Checklist:	
What If/Checklist:	
HAZOP:	
Failure Mode and Effects Analysis:	
Fault Tree Analysis:	
Other Technique Used:	

PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update):

15-Nov-2009

Major Hazards Identified

Toxic Release:	Yes
Fire:	Yes
Explosion:	
Runaway Reaction:	
Polymerization:	
Overpressurization:	Yes
Corrosion:	Yes
Overfilling:	Yes
Contamination:	
Equipment Failure:	Yes
Loss of Cooling, Heating, Electricity, Instrument Air:	Yes
Earthquake:	Yes
Floods (Flood Plain):	
Tornado:	
Hurricanes:	
Other Major Hazard Identified:	Operator Error

Process Controls in Use

Vents:	Yes
Relief Valves:	Yes
Check Valves:	Yes
Scrubbers:	
Flares:	
Manual Shutoffs:	Yes
Automatic Shutoffs:	Yes
Interlocks:	Yes
Alarms and Procedures:	Yes
Keyed Bypass:	
Emergency Air Supply:	
Emergency Power:	
Backup Pump:	
Grounding Equipment:	
Inhibitor Addition:	
Rupture Disks:	
Excess Flow Device:	
Quench System:	
Purge System:	Yes
None:	
Other Process Control in Use:	

Mitigation Systems in Use

Sprinkler System:	Yes
Dikes:	
Fire Walls:	Yes
Blast Walls:	
Deluge System:	
Water Curtain:	
Enclosure:	Yes

Neutralization:

None:

Other Mitigation System in Use: diffuser tank

Monitoring/Detection Systems in Use

Process Area Detectors: Yes

Perimeter Monitors:

None:

Other Monitoring/Detection System in Use:

Changes Since Last PHA Update

Reduction in Chemical Inventory:

Increase in Chemical Inventory:

Change Process Parameters:

Installation of Process Controls:

Installation of Process Detection Systems:

Installation of Perimeter Monitoring Systems:

Installation of Mitigation Systems:

None Recommended:

None: Yes

Other Changes Since Last PHA or PHA Update:

Review of Operating Procedures

Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures): 15-Oct-2009

Training

Training Revision Date (The date of the most recent review or revision of training programs): 15-Jan-2009

The Type of Training Provided

Classroom: Yes

On the Job: Yes

Other Training:

The Type of Competency Testing Used

Written Tests:

Oral Tests: Yes

Demonstration: Yes

Observation: Yes

Other Type of Competency Testing Used:

Maintenance

Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures): 15-Jan-2009

Equipment Inspection Date (The date of the most recent equipment inspection or test): 15-Jan-2009

Equipment Tested (Equipment most recently inspected or tested): ALL

Management of Change

Change Management Date (The date of the most recent change that triggered management of change procedures):

Change Management Revision Date (The date of the most recent review or revision of management of change procedures): 15-Jan-2009

Pre-Startup Review

Pre-Startup Review Date (The date of the most recent pre-startup review):

Compliance Audits

Compliance Audit Date (The date of the most recent compliance audit): 15-Jan-2009

Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit): 15-Nov-2009

Incident Investigation

Incident Investigation Date (The date of the most recent incident investigation (if any)):

Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation):

Employee Participation Plans

Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans): 15-Jan-2009

Hot Work Permit Procedures

Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures): 15-Jan-2009

Contractor Safety Procedures

Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures): 15-Jan-2009

Contractor Safety Performance Evaluation Date
(The date of the most recent review or revision of
contractor safety performance):

Confidential Business Information

CBI Claimed:

Section 8. Program Level 2

Section 9. Emergency Response

Written Emergency Response (ER) Plan

Community Plan (Is facility included in written community emergency response plan?): Yes

Facility Plan (Does facility have its own written emergency response plan?): Yes

Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?): Yes

Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?): Yes

Healthcare (Does facility's ER plan include information on emergency health care?): Yes

Emergency Response Review

Review Date (Date of most recent review or update of facility's ER plan): 23-Feb-2005

Emergency Response Training

Training Date (Date of most recent review or update of facility's employees): 23-Feb-2005

Local Agency

Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated): Arizona Emergency Response Committee

Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated): (602) 231-6345

Subject to

OSHA Regulations at 29 CFR 1910.38: Yes

OSHA Regulations at 29 CFR 1910.120: Yes

Clean Water Regulations at 40 CFR 112:

RCRA Regulations at CFR 264, 265, and 279.52:

OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254:

State EPCRA Rules or Laws: Yes

Other (Specify):

Executive Summary

1. Accidental Release Prevention and Emergency Response Policy

Taylor Farms Food Services operates a salad processing, shipping and cooling facility in Yuma, AZ. Risk prevention and emergency response procedures are in place at this facility. The Emergency Response Plan lists the responsible personnel and the policies for responding to an accident involving the regulated substance.

Taylor Farm Food Services facility has fixed and portable refrigeration system onsite. Fixed system is composed of pressure vessels, ammonia pumps, plate frame heat exchangers, falling film water chillers, evaporative cooling coils, portable refrigeration trailers and diffusion tank. Refrigeration trailers contain compressors, vessels, vacuum tube coils, and evaporative condensers. All compressors have safety switches that would shut down the compressors upon detection of unsafe operating conditions. All the pressure vessels and the compressors are protected by safety relief valves against high pressure situations. There are ammonia detectors in the cold rooms for alarming. There is a list of responders experienced with ammonia refrigeration that would respond and determine specific responses for any incident. Safeties and detection equipment are tested and maintained by experienced maintenance personnel as spelled out in the SOPs (Standard Operating Procedures) and testing and inspection program. Emergency response training will be conducted yearly for current employees and as required for new employees. Records will be kept of all training performed at the site for a minimum of five (5) years.

2. Description of Source and Substance Handled

Ammonia refrigeration system is used for produce precooling, storage and process room cooling and water chilling operations.

Taylor Farms Retail Services purchased the facility in 2008 and replaced/modified some pressure vessels and added process chillers. The total charge for the refrigeration system is approximately 25,000 LBS.

Anhydrous ammonia (NH₃) is a gas in its natural state and is extremely irritating to mucous membranes and lung tissue. The gas is pungent and may be suffocating as shortness of breath and labored breathing can develop if inhaled. Prolonged inhalation of high concentrations may cause bronchitis and/ or pneumonia, with some residual reduction in pulmonary functions. Repeated or prolonged contact of high concentrations of ammonia to the skin can cause frostbite, redness, pain and serious skin burn.

3. Accidental Release Prevention Program

Taylor Farms Food Services maintains a release prevention program to eliminate or minimize releases. The program includes regular inspections, monitoring equipment and logging conditions, scheduled maintenance, and operator training. Incident Investigation program is in place to analyze releases for ways to prevent a similar future release.

The ammonia refrigeration system has specific safety procedures to prevent a release. Operators and mechanics are trained for safe operation and maintenance of the refrigeration system. They are also trained in emergency response procedures in the event of an ammonia release. Ammonia detectors are installed in all refrigerated rooms. Personnel will automatically be notified if any detector exceeds set point. Monitoring is 24 hours per day. Most relief valves at the facility are tied into ammonia diffusion tank to prevent high pressure releases to ambient.

4. Emergency Response Program

In the event of a release, certain personnel are designated to determine the potential hazard and coordinate response procedures. The Hazmat Team Chief is responsible in coordinating emergency response and will be contacting emergency response agencies, schools, daycare centers, and acute care facilities that may be affected by the release. The Hazmat Team Chief will also be responsible for evacuation of employees if necessary and for coordination with community emergency responders if off-site evacuations are required.

5. Five-Year Accident History

According to Taylor Farms Food Service personnel, since startup there have been no releases of anhydrous ammonia resulting in reportable quantities or injuries.

6. Planned Safety Improvements

Specific recommendations resulting from the PHA and safety inspection are provided to facility personnel. All refrigeration equipment is well maintained and operated in a safe manner by trained personnel. Operating, maintenance, training, and safety procedures will be formalized with improved written documentation.